

Date: Wednesday, 14/01/2009 4:22:55 PM
 User: Julie Dawson

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : FLOAT STEP MOUNTING LUG
Job Number : 44608	
Estimate Number : 11755	
P.O. Number :	Part Number : D34647
This Issue : 14/01/2009 S.O. No. :	Drawing Number : D3464
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : SMALL /MED FAB	Drawing Revision : A
Previous Run : 44608	Material :
Written By :	Due Date : 30/01/2009 Qty: 20 Um: Each
Checked & Approved By : <u>JLD 09.01.14</u>	
Comment : Est Rev: A New Issue 06-01-06 JLM Est Rev:B 09-01-14 now made on waterjet DD verified by:EC	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6B0187X04000	6061-T6 Bar .178 x 4.00
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Comment: Qty.: 0.3941 f(s)/Unit Total : 7.8813 f(s)
 4.00" X .188" BAR
 6061-T6
 (M6061T6B4.000X.188)
 Batch: 106652 IB 9-4-5

2.0	WATER JET	FLOW WATER JET
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(Pb) →

Comment: FLOW WATER JET
 1-Cut as per Dwg D3464
 Dwg Rev: A
 Prog Rev: A

IB 9-4-5

(20)

2-Deburr if necessary IB 9-4-5

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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**Comment:** INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
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**Comment:** SECOND CHECK

D 08/04/06 (19)

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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**Comment:** Deburr if necessary.

m. d

09/04/06 (19x)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3464-7 PAR #: N/A Fault Category: Prod - Sm. Fab NCR: Yes No DQA: lt Date: 09.06.23
 Resolution: Scrap Disposition: Scrap QA: N/C Closed: lt Date: 09.07.15

NCR: <u>44608</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
9/4/6	# 20	Found at one (qty 10) part with large chatter marks from water jet. Causing D.M 0.461" to measure 0.431".	<u>lt</u>	Scrap Qty 1; No replace.	<u>lt</u> 9-4-6	<u>lt</u> 09/04/06	<u>lt</u> 09/04/06	<u>lt</u> 09/04/06
		P.C. machine malfunction.						

NOTE: Date & initial all entries

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Drawing Name: FLOAT STEP MOUNTING LUG

Job Number: 44608

Part Number: D34647

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

509/04/06 (x18)

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: WA

09.06.23 19

8.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/06/23

Job Completion



mf
09-06-23

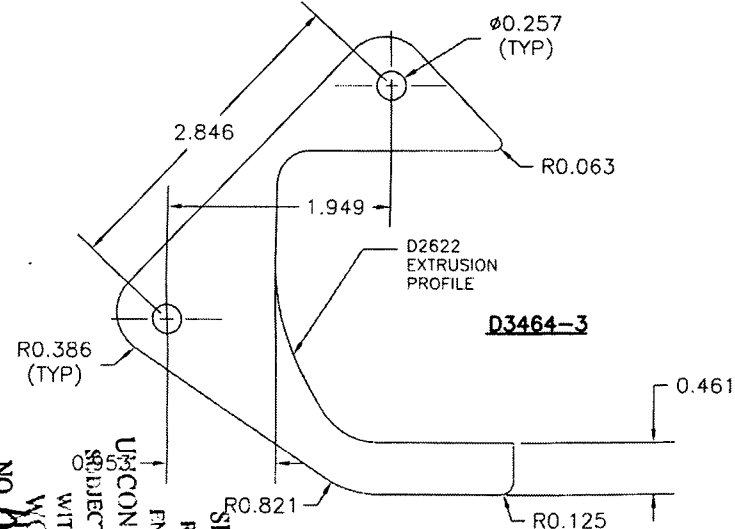
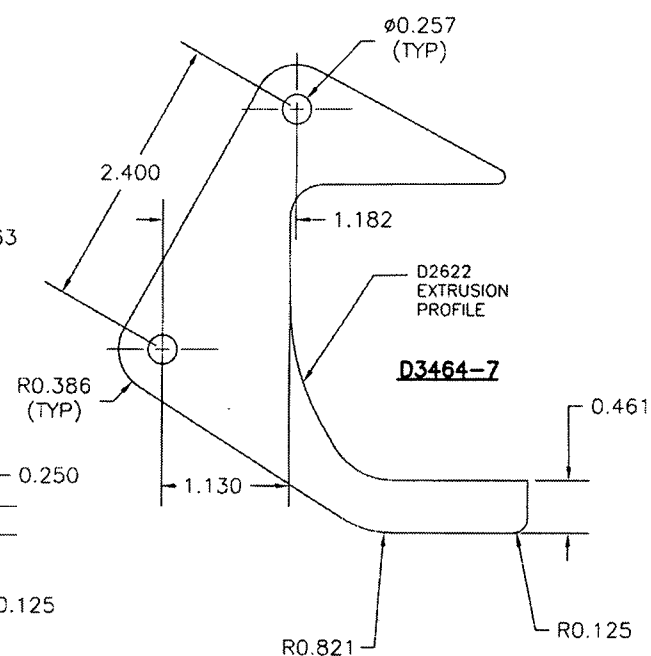
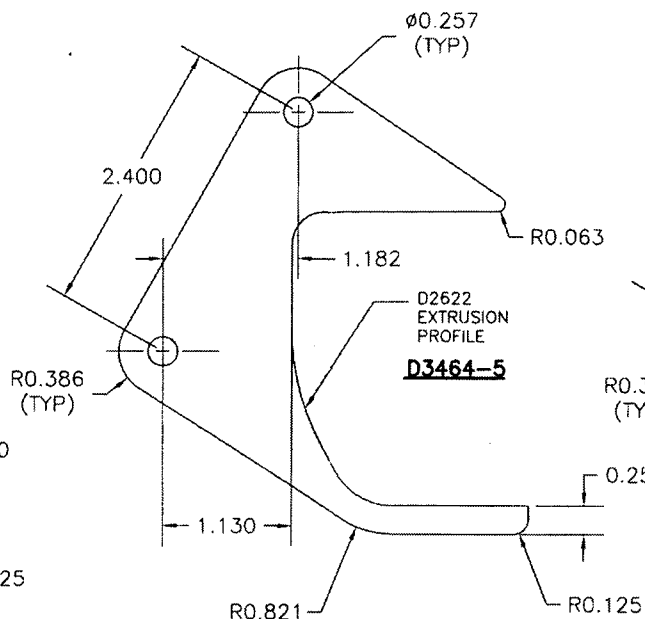
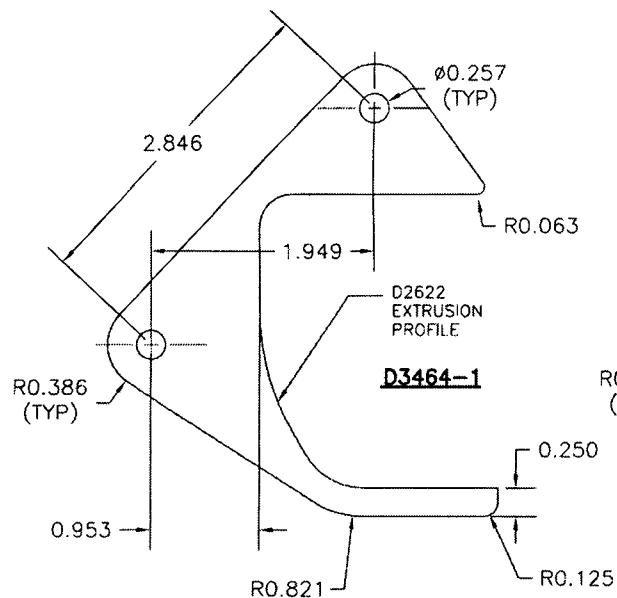
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D3464-1/-3/-5/-7 FLOAT STEP MOUNTING PLATE

- 1) MATERIAL: ALUMINUM 6061-T6 (QQ-A-250/11) 0.188 THICK
(REF DART SPEC. M6061T6S.188)
- 2) FINISH: NONE
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

RELEASED
65.1.14

A		05.09.21	NEW ISSUE
DESIGN	PH	DRAWN BY	PH
CHECKED	PH	APPROVED	PH
DATE	05.09.21	TITLE	FLOAT STEP MOUNTING PLATE
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		D3464	SHEET 1 OF 1
		SCALE	1:1

NO. 11002
 WORK ORDER
 WITH OUT NOTICE
 SUBJECT TO AMENDMENT
 UNCONTROLLED COPY
 RETURN TO
 ENGINEERING
 SHOP COPY